

Work Order ID 61434

Wednesday, August 25, 2010 9:13:23 AM



Page 1

Item ID:	D3852-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly					
Start Date:	8/25/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	9/1/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date: 10-8-25	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3852	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	<p>1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig</p> <p>2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852</p> <p>3- c'sink hole as per dwg</p> <p>4- remove identification markings</p> <p>5- deburr</p> <p>6- weld D3759-1 bushing as per dwg D3852</p> <p>A/R ER316 S.S. Rod Batch: M114649</p> <p>7- grind bushing weld flush as per dwg dwg D3852 ✓</p> <p>8- deburr hole if necessary ✓</p>								

SAD 10:09-09

10/09/16 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61434

Wednesday, August 25, 2010 9:13:23 AM



Page 2

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 8/25/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10/09/21

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/02/21

74
2421

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Basket cell

Memo

0.00

0.00

10/09/22 74

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 8/25/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/22
CL1019/22

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Picklist Print

Wednesday, August 25, 2010 9:13:28 AM

Page 1

Work Order ID: 61434

Parent Item: D3852-042

Parent Item Name: Rib Assembly



Start Date: 8/25/2010

Required Date: 9/1/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3166-3  Basket Hoop		Manufactured	No			100	Each	5.0418	0.18	0.378947			
<div> <div> <u>Location</u> WA 55697 59266 60270 </div> <div> <u>Loc Qty</u> 5.041821053 2.1053E-05 0.0418 5 </div> <div> <u>Loc Code</u> </div> </div>													
✓ D3759-1  Bushing		Manufactured	No			100	Each	91.0000	1	2			
<div> <div> <u>Location</u> ST084 56942 WA 54072 61348 </div> <div> <u>Loc Qty</u> 60 60 31 9 22 </div> <div> <u>Loc Code</u> </div> </div>													

SAD 10-09-09

0.37895 x 2 = 7579
10/09/16

24

W/O:		WORK ORDER CHANGES					
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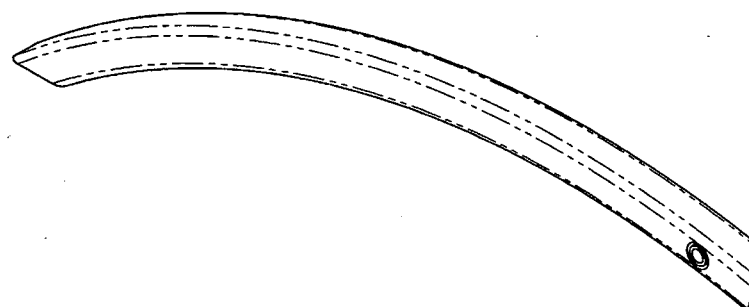
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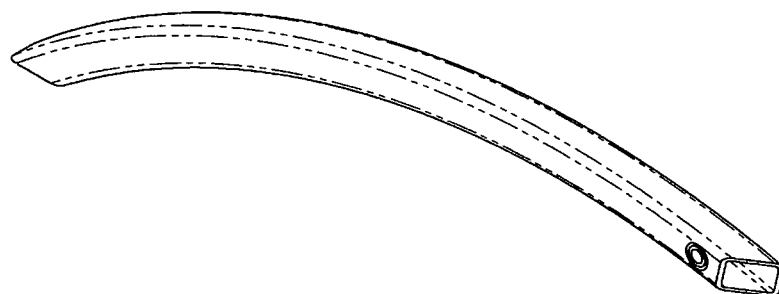
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 61434
PS 10-8-25

RELEASED
08/11/07 M.P.

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852**

TITLE **RIB ASSEMBLY**

REV. A
SHEET 1 OF 3
SCALE
NTS

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8 7 6 5 4 3 2 1

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8 7 6 5 4 3 2 1

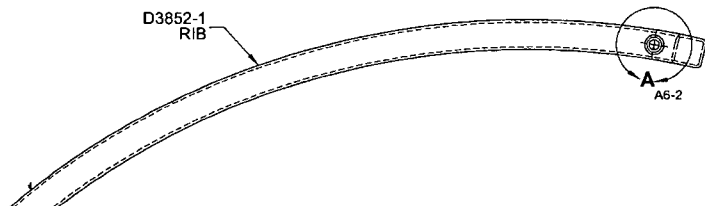
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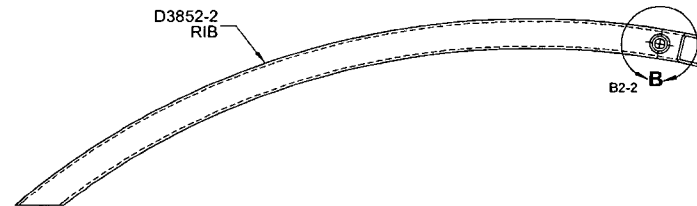
D

C

D3852-1
RIB



D3852-2
RIB



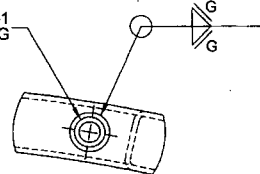
C

D3852-041 RIB ASSEMBLY

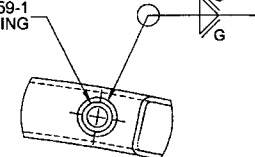
D3852-042 RIB ASSEMBLY

B

D3759-1
BUSHING



D3759-1
BUSHING



B

DETAIL A
SCALE 2X C5-2

DETAIL B
SCALE 2X C2-2

A

w/b 61439

RELEASED

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	08.11.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

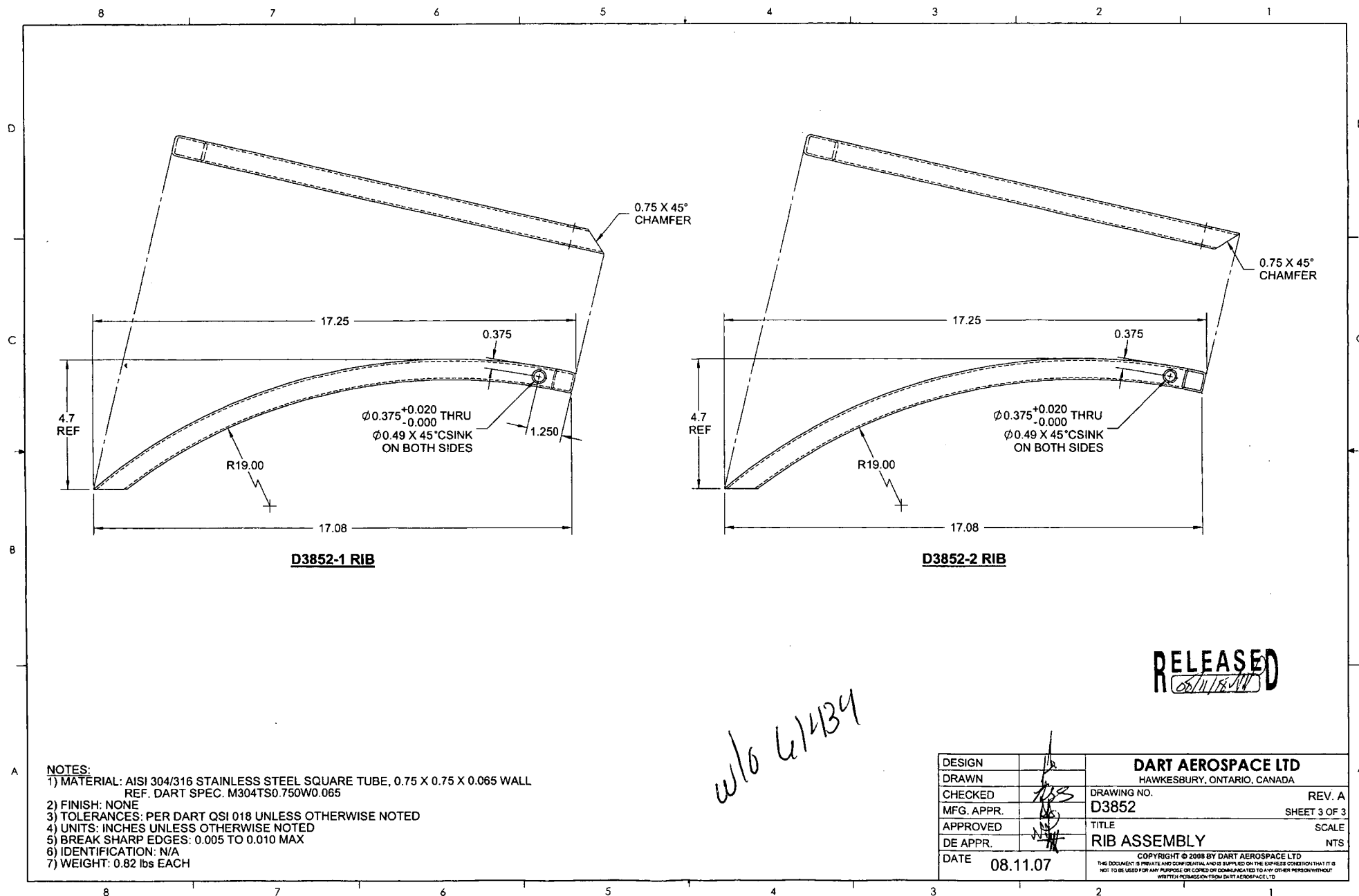
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Dart Aerospace Ltd

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